

Work Order ID 58498

Friday, May 07, 2010 2:22:05 PM



ASAP

Shipping Monday Page 1

Item ID: D3639-4

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 5/10/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/10/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: umf

Date: 10-5-7

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3639	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3639 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B 10-5-10

(10)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-5-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/10/05/10

(XJ) (XJ)

Phu →

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3639-4 PAR #: _____ Fault Category: Small Fats NCR: (Yes) No DQA: _____ Date: 10/05/10
 Resolution: _____ Disposition: _____ QA: N/C Closed: [Signature] Date: 10/05/10

NCR: 58498		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/5/10	# 110	Found QH x 5 Parts with lead in/lead out on different hubs. RC: process/water jet	[Signature]	- Scrap & Destroy QH x 4 no further extra made	[Signature] 10/5/10	[Signature] 10/05/10	[Signature] 10/05/10	[Signature] 10/05/10

NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3639

0.00

0.00

86 10/05/10

(5)

6

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S. 10/05/10

(45)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

M 10/05/10

5

d

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 5/10/2010 Req'd Qty: 4.00



Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(5) 10-5-10

170

Identify as per dwg & Stock Location: 243

0.00



Packaging

Memo

0.00

Packaging

C. C. 10/10 (5)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/10 (5)
WME 10-5-10

W/O:			WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, May 07, 2010 2:22:04 PM

Page 1

Work Order ID: 58498



Parent Item: D3639-4



Parent Item Name: Doubler

Start Date: 5/10/2010

Required Date: 5/10/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	43.3947	0.4277	22 1.1		



HB10-540

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

43.3947

111381

32

112291

11

113189

0.3947

111381



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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 58498
Description: Doubler		Part Number: D3639-4
Inspection Dwg: D3639	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.625	X			
Ø0.191	+0.005/-0.001	.192	X			
Ø0.098	+0.004/-0.001	.100	X			
0.45	+/-0.030	.447	X			
1.350	+/-0.010	1.350	X			
2.25	+/-0.030	2.251	X			
3.15	+/-0.030	3.151	X			
4.05	+/-0.030	4.055	X			
4.95	+/-0.030	4.950	X			
5.85	+/-0.030	5.848	X			
6.75	+/-0.030	6.755	X			
7.65	+/-0.030	7.659	X			
8.55	+/-0.030	8.553	X			
9.350	+/-0.010	9.354	X			
9.45	+/-0.030	9.451	X			
10.350	+/-0.010	10.351	X			
11.25	+/-0.030	11.255	X			
12.15	+/-0.030	12.15	X			
12.85	+/-0.030	12.85	X			REND
13.86	+/-0.030	13.86	X			
13.96	+/-0.030	13.96	X			
0.805	+/-0.010	.810	X			
1.00	+/-0.030	1.002	X			
2.100	+/-0.010	2.100	X			
3.30	+/-0.030	3.307	X			
2.000	+/-0.010	2.000	X			
2.590	+/-0.010	2.592	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-5-10	Date: 10/5/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	

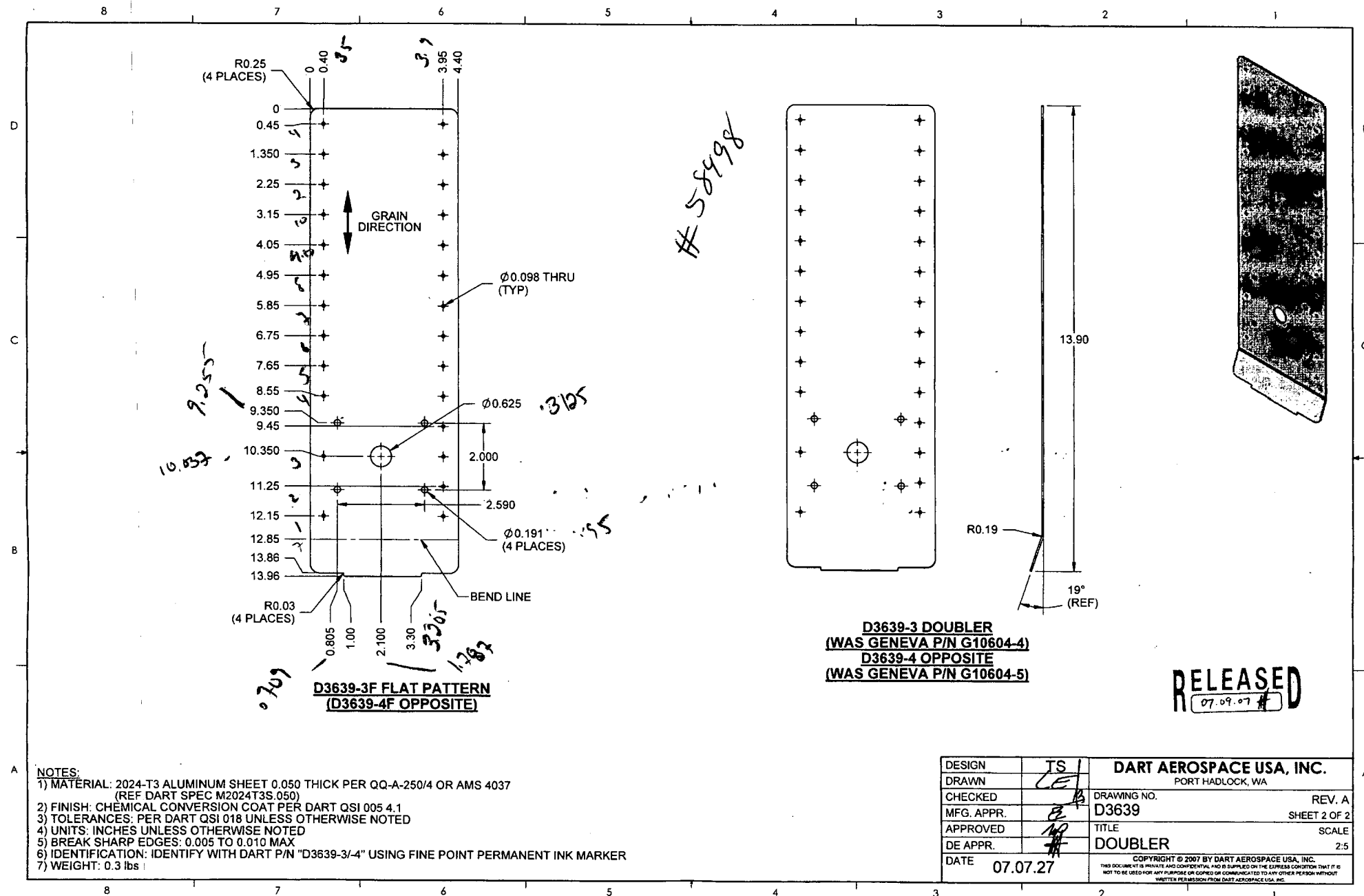
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RELEASE
07.09.07 #

W/O:			WORK ORDER CHANGES					
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